

Date: Friday, 3/16/2007 1:13:02 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/0H-58 SADDLE, INBOARD, LEFT SIDE - UNDER REVIEW		
Job Number	: 31252		Part Number	: D29391		
Estimate Number	: 10836		Drawing Number	: D2939 UNDER REVIEW		
P.O. Number	: N/A		Project Number	: N/A CB 07.03.16		
This Issue	: 3/16/2007 S.O. No. : N/A		Drawing Revision	: B/C		
Prshf Rev.	: NC		Material	: N/A		
First Issue	: 3/16/2007 Type : MACHINED PARTS		Due Date	: 3/30/2007 Qty: 8 Um: Each		
Previous Run	: 30482					
Written By	:					
Checked & Approved By	:					
Comment	: Est: B 00.06.26 New DWG rev (mpp.2069) EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6101001	7075-T7351 2X6X6.25	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: 805345	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 805345 1-Inspect part number and batch number are programmed correctly. 805345 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 5-Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07KB130  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 3/16/2007 1:13:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER  
REVIEW

Job Number: 31252

Part Number: D29391

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 07/03/27 8

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(8)

Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

m-f

07/03/27

7.0 POWDER COATING POWDER COATING



m103141

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SL

07/03/28 ⑧

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EPA07/03/29⑧

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EPA07/03/29⑧

10.0 QC21 FINAL INSPECTION/W/O RELEASE



⑧

Comment: FINAL INSPECTION/W/O RELEASE

SD 07/03/30

Job Completion



✓ ST. 03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	
Description: 206 Saddle, Inboard, Left side				Part Number: D2939-1	
Inspection Dwg: D2939 Rev. B C				Page 1 of 1	

CB 07.03.16

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.125	.125	.125		
B	0.100	0.140		.121	.125	.125	.125		
C	0.100	0.140		.132	.139	.139	.139		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.246	1.250	1.250	1.250		
F	1.245	1.255		1.246	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.575	1.577	1.577	1.577		
J	2.495	2.505		2.497	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.255	.255	.255	.255		
L	0.312	0.317	DT8686	.315	.315	.315	.315		
M	0.235	0.240		.240	.240	.240	.240		
N	0.100	0.140		.125	.125	.125	.125		
O	0.540	0.560		.544	.544	.544	.544		
P	0.490	0.510		.495	.495	.495	.495		
Q	3.715	3.725		3.716	3.720	3.720	3.720		
R	2.720	2.760		2.756	2.740	2.744	2.744		
S	0.240	0.270		.253	.253	.253	.253		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.639	1.630	1.630	1.630		
V	1.362	1.372		1.366	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.320	.320	.320	.320		
X	1.250	1.270		1.260	1.259	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	—	—	—	—		
Z	0.015	0.035		.025	.025	.025	.025		
AA	6.990	6.90		6.000	6.002	6.002	6.002		
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	Er. BGS	Audited by:	JL
Date:	07.03.27	Date:	07/03/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

DART AEROSPACE LTD				Work Order:	
Description: 206 Saddle, Inboard, Left side		Part Number:		D2939-1	
Inspection Dwg: D2939 Rev. B/C				Page 1 of 1	

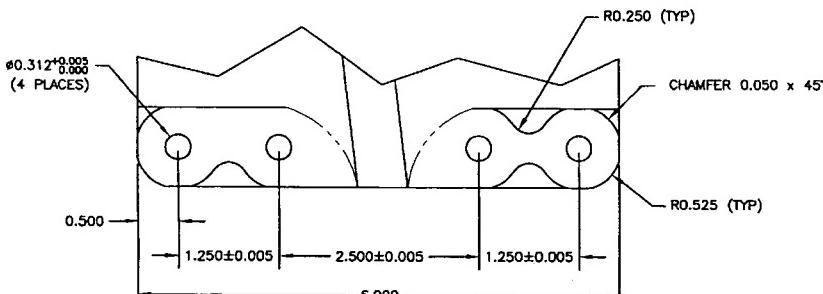
(B) 07.03.16

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.125	.125	.125	.125		
C	0.100	0.140		.135	.135	.135	.135		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.260	.260	.260	.260		
L	0.312	0.317	DT8686	.314	.314	.314	.314		
M	0.235	0.240		.240	.240	.240	.240		
N	0.100	0.140		.135	.135	.135	.135		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.722	3.722	3.722	3.722		
R	2.720	2.760		3.742	3.742	3.742	3.742		
S	0.240	0.270		.260	.260	.260	.260		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.320	.320	.320	.320		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

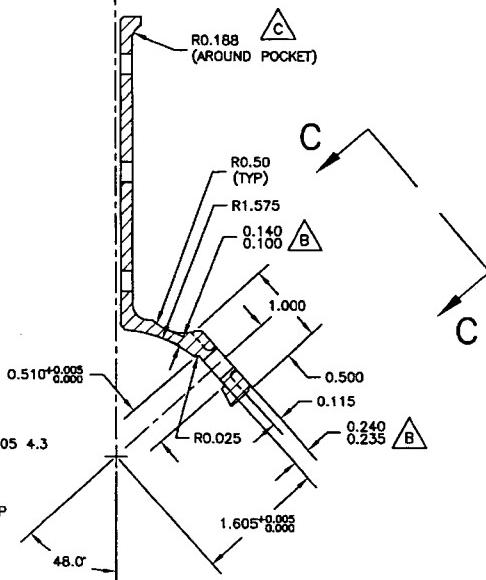
Measured by:	BF	Audited by:	J.L
Date:	07.03.27	Date:	07/03/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



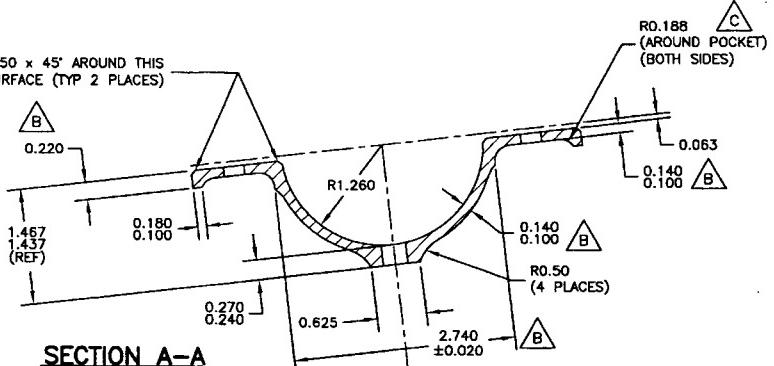
VIEW C-C

D2939-1 LH SADDLE (SHOWN)  
D2939-2 RH SADDLE (OPPOSITE)

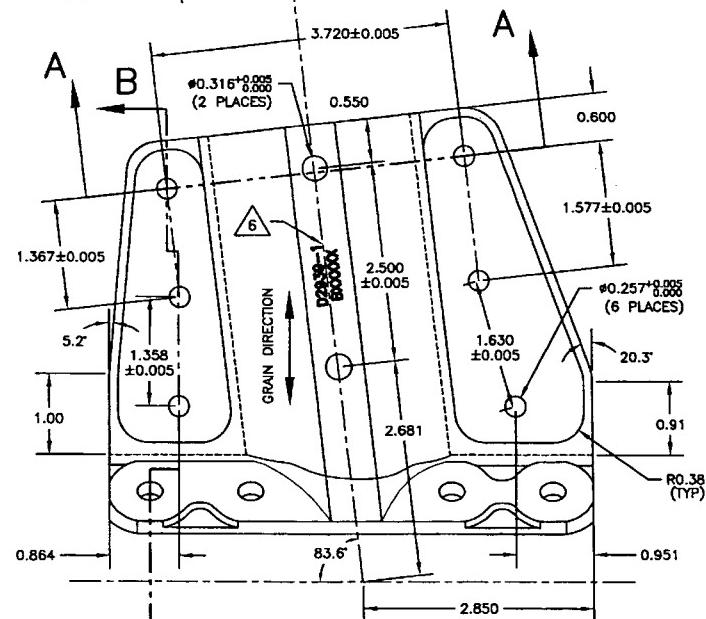


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	D2939
DATE	REV. C	SHEET 1 OF 1
06.11.09	SCALE	2:3
SADDLE INSIDE		

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NO.

07.02.12